

Work Order ID 93107

November-14-12 11:18:50 AM

rust

93107

Page 1

Item ID: D2855-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cap

Start Date: 11/14/12 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2855	Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *18407*
Cast per Dwg D2855
Material Release Note Required

CL 1211114 (24)

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

12/11/12 (24)

120

0.00

120

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

DAS 16

12/11/12

(24) Count

Work Order ID 93107

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November-14-12 11:18:50 AM

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Accept

N900040100

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Stop *NS2*

Item Name: Cap

Start Date: 11/14/12 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					24	0		JM 12-11-26
Small Fab	Memo	0.00							
Small Fab	1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Cut to length as per dwg 4- Deburr								12-11-26
140	QC5- Inspect part completeness to step on W/O	0.00							
140						24			
QC	Memo	0.00							can
Quality Control									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:30 OVEN TEMPERATURE: 325°F FINISH TIME: 12:00								24x✓ 12/11/28

M123353

93107

November-14-12 11:18:50 AM

N900040100

Setup Start *NS1*

Stop *NS2*

24

Cust Item ID:

24

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

160

Memo

0.00

Quality Control

0.00

170

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

0.00

180

QC

Memo

0.00

Quality Control

Work Order ID 93107

93107

Page 4

November-14-12 11:18:50 AM

Item ID: D2855-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cap

Start Date: 11/14/12 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/28/12 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: FP-002 0.00

190

Packaging

Memo

0.00

Packaging

x24 f 30 11/14/12

200

QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

12/11/28 DJ

MF
12-11-28

Picklist Print

November-14-12 11:18:50 AM

Page 1

Work Order ID: 93107

Parent Item: D2855-3

Parent Item Name: Cap

Start Date: 11/14/12

Required Date: 11/28/12

Start Qty: 24.00

Required Qty: 24.00

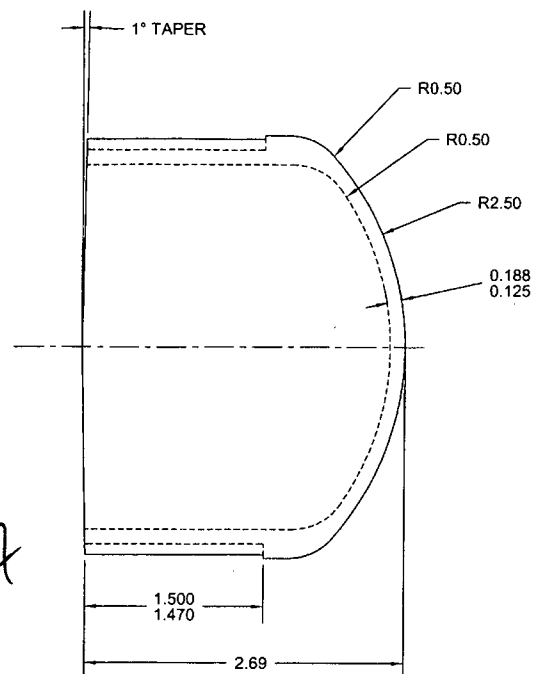
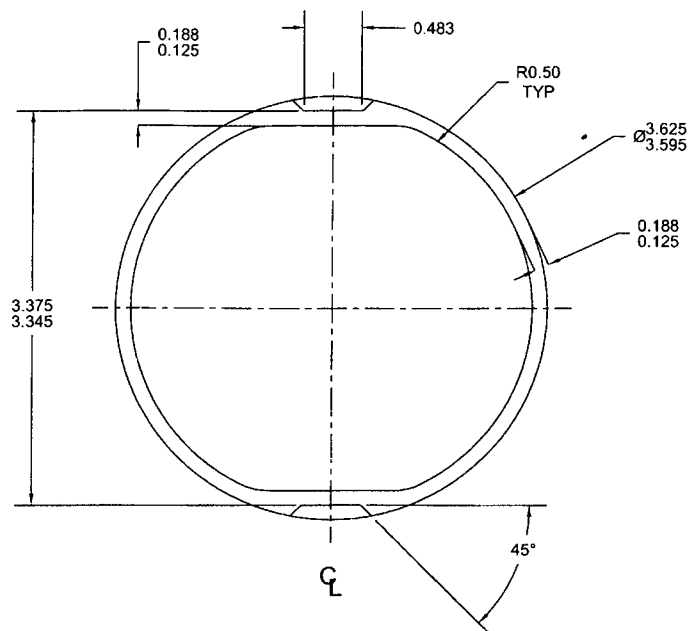
Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 INSERT		Purchased	No			170	Each	4,030.0000	2	48		11/14/12	

Location	Loc Qty	Loc Code
FG	100	
118520	100	
FP-B	2134	
122290	2134	
ST282	1796	
100896	135	
111529	27	
118520	634	
122333	1000	

D2855P Cap		Purchased	No			110	Each	0.0000	1	24			
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Carroll/23 (24)



01093107

D2855C CASTING DETAIL

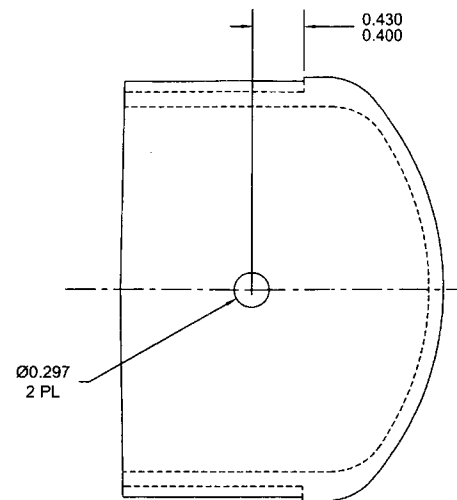
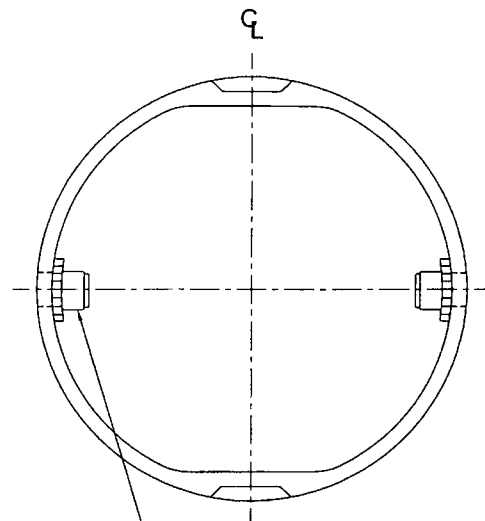


RELEASED
09/07/15 MB

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)		RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)		DS	96.12.12
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>RF</i>			
MFG. APPR.	<i>RF</i>			
APPROVED	<i>RF</i>			
DE APPR.	<i>RF</i>	DRAWING NO.	REV. E	
		D2855	SHEET 1 OF 1	
		TITLE	SCALE	
		CAP	NT.	
DATE	09.06.30		COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

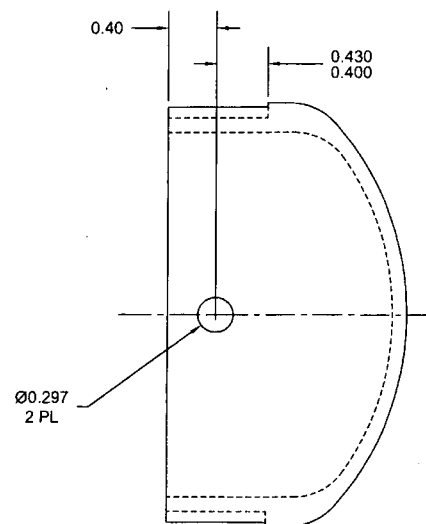
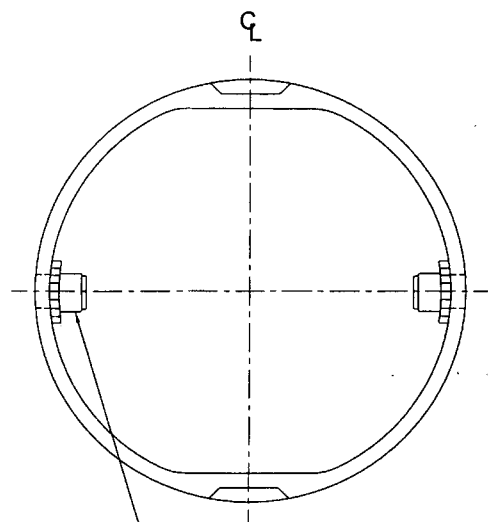
D2855 CAP (MAKE FROM D2855C CASTING)

NOTES:


- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2/17/15 MP

DESIGN		DS		DART AEROSPACE LTD	
DRAWN		RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED		RF		DRAWING NO.	REV. B
MFG. APPR.		RF		D2855	SHEET 2 OF 3
APPROVED		RF		TITLE	SCALE
DE APPR.		RF		CAP	NTS
DATE		09.06.30		COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
2017/5/10

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B		
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 3 OF 3		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	CAP	NTS		
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD			
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DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053**PURCHASE ORDER**

Purchase Order ID PO18407

Purchase Order Date 11/14/12

PO Print Date 11/14/12

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA**Contact Name****Vendor Phone**

514 683 9777

Vendor Fax

514 683 0375

Vendor Account Nbr**Buyer**

Chantal Lavoie

Requisition Nbr**Tax Resale Nbr**

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

FAXED**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA**REVISED**

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	11/23/12 Yes	24.00 Each	FedEx PI collect	\$18.7000	\$448.80
Special Inst: AS PER DWG D2855 REV. B B93107 PLEASE ADVISE DELIVERY ORDER REQUIRED ASAP							
2	D2855P	Cap	11/23/12 Yes	26.00 Each	FedEx PI collect	\$18.7000	\$486.20
Special Inst: AS PER DWG D2855 REV. B B93143							

PO Total:**\$935.00**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERYMATERIAL CERTIFICATION
REQ'D UPON DELIVERY*Please advise delivery.*No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 3

Change Date: 11/14/12

Aluminum Foundry Ltd

2225 Chemin St. Francois

Dorval, Québec H9P 1K3

Tel: (514) 683-9777

Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 34191

Shipped Date: 22 11 2012

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 018407	
Shipped By: Fedex	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	50
		Received by:	
		Date:	
Comment:			

CERTIFICAT DE CONFORMITE
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

2225 Chemin St. Francois, DORVAL, QC H9P-1K3
TEL : (514) 683-9777 FAX: (514) 683-1375

Expédié à
Shipped

DART AEROSPACE

A. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **22/11/2012** Slip No. **34191**

Hawksbury, ON, K6A 1K7

Votre No. Commande **18407**
Your order no.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en file dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50pcs	D 2855 CAP	Z098046	<div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center;"> A 16.2 </div> <i>Sizulu</i>	ingot#C6250772 B#1232601
Analyse Analysis (as in Ingot)				
(Si)	7.20%	(Al)	balance	
(Fe)	0.12%	(S3)	0.027	
(Cu)	<0.01%			
(Mn)	<0.01%			
(Mg)	0.39%			
(Zn)	<0.01%			
(Ti)	0.13%			
Donne Yield :	Résistance à la tension : Tensile Strength :	Allongement par pouce carré : Elongation : %		

Pour et au nom de :
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100